



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**RBW6305G01232-3G-PO**

**Job Sheet 191247**



**Part No:** RBW6305G01232-3G-PO **Job Qty:** 2 pcs

**Part Name:** Gimbal Torque Tube Bushing Remover



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 2/25/19

**Job Tracking No:**

**Due Date:** 4/29/19

**Created By:** Patrick Lussier

**Type:** Stock

**Description:**

**Note:** DWG RB 92700-10301-041 Rev.A IPP Rev. A 18.11.26 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                     | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier    |           | Sign-off    |
|-------|-------------------------------|-------|------------|----------|-----------|---------|------------------------|-----------|-------------|
|       |                               |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier  | Lead Time |             |
| 100   | Purchasing                    | 2 pcs | 4/29/19    | 4/29/19  | 0.00      | 0.00    | Purchasing - 1         |           | APR 01 2019 |
|       |                               |       |            |          |           |         | Purchasing - 2         |           |             |
|       |                               |       |            |          |           |         | Purchasing - 3         |           |             |
| 110   | Packaging 2-1 - Receive - B4B | 2 pcs | 4/29/19    | 4/29/19  | 0.00      | 0.00    | Packaging 2 - 1 - B4B  |           | APR 01 2019 |
|       |                               |       |            |          |           |         | Packaging 2 - 2 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 3 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 5 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 4 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 6 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 7 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 8 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 9 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 10 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 11 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 12 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 13 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 14 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 15 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 16 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 17 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 18 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 19 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 20 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 21 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 22 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 23 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 24 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 25 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 26 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 27 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 28 - B4B |           |             |

Dart Aerospace Ltd.  
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CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com



**Container No:** S168081



**Part:** RBW6305G01232-3G

**Job No:** 191247

**Serial No/Batch:** S168081

**Revision:** 3

**Inspector:**

**Exp Date:**

**Instructions:**

**Date:** 04/01/19

|                                 |       |         |      |      |                        |                |
|---------------------------------|-------|---------|------|------|------------------------|----------------|
|                                 |       |         |      |      | Packaging 2 - 29 - B4B |                |
|                                 |       |         |      |      | Packaging 2 - 30 - B4B |                |
|                                 |       |         |      |      | Packaging 2 - 31 - B4B |                |
|                                 |       |         |      |      | Packaging 2 - 32 - B4B |                |
|                                 |       |         |      |      | Packaging 2 - 33 - B4B |                |
|                                 |       |         |      |      | Packaging 2 - 34 - B4B |                |
|                                 |       |         |      |      | Packaging 2 - 35 - B4B |                |
|                                 |       |         |      |      | Packaging 2 - 36 - B4B |                |
| 120 QC 6                        | 2 pcs | 4/29/19 | 0.00 | 0.00 | QC 6 - 42              |                |
|                                 |       |         |      |      | QC 6 - 9               | DAS            |
|                                 |       |         |      |      | QC 6 - 68              | APR 01 2019 68 |
| 130 Packaging 3-1 - Stock - B4B | 2 pcs | 4/29/19 | 0.00 | 0.00 | Packaging 3 - 1 - B4B  | 9-89           |
|                                 |       |         |      |      | Packaging 3 - 2 - B4B  |                |
|                                 |       |         |      |      | Packaging 3 - 3 - B4B  |                |
|                                 |       |         |      |      | Packaging 3 - 4 - B4B  |                |
|                                 |       |         |      |      | Packaging 3 - 5 - B4B  | DAS            |
|                                 |       |         |      |      | Packaging 3 - 6 - B4B  | 28             |
|                                 |       |         |      |      | Packaging 3 - 7 - B4B  | 9-89           |
|                                 |       |         |      |      | Packaging 3 - 8 - B4B  |                |
|                                 |       |         |      |      | Packaging 3 - 9 - B4B  |                |
|                                 |       |         |      |      | Packaging 3 - 10 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 11 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 12 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 13 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 14 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 15 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 16 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 17 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 18 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 19 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 20 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 21 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 22 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 23 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 24 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 25 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 26 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 27 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 28 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 29 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 30 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 31 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 32 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 33 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 34 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 35 - B4B |                |
|                                 |       |         |      |      | Packaging 3 - 36 - B4B |                |
| 140 QC 21 - SA                  | 2 pcs | 4/29/19 | 0.00 | 0.00 | QC 21 - SA - 21        | DAS            |
|                                 |       |         |      |      | QC 21 - SA - 70        | 21 APR 01 2019 |

Part Op 100 - -Issue P/O to ARROW TECH MACHINE WORKS ; P/O \_\_\_\_\_ -Manufacture RBW6305G01232-3G as  
 Descriptions: per DWG. -Certificate of Conformity is required  
 110 - Certificate of Conformity is required

**PO Details**

Arrow Tech Machine Works (arr002-vu)



PO No: PO042703

Line No: 1

**Job BOM**

| Part / Item       | Component Name                     | Quantity    | Operation      | Container |
|-------------------|------------------------------------|-------------|----------------|-----------|
| RBW6305G01232-3GP | Gimbal Torque Tube Bushing Remover | 2 Ea (1 ea) | 100-Purchasing | 5168080   |

**Job Allocations**

| Operation      | Component Part    | Required | Inventory | Allocated |
|----------------|-------------------|----------|-----------|-----------|
| 100-Purchasing | RBW6305G01232-3GP | 2        | 0         | 0         |

**Part Specifications**

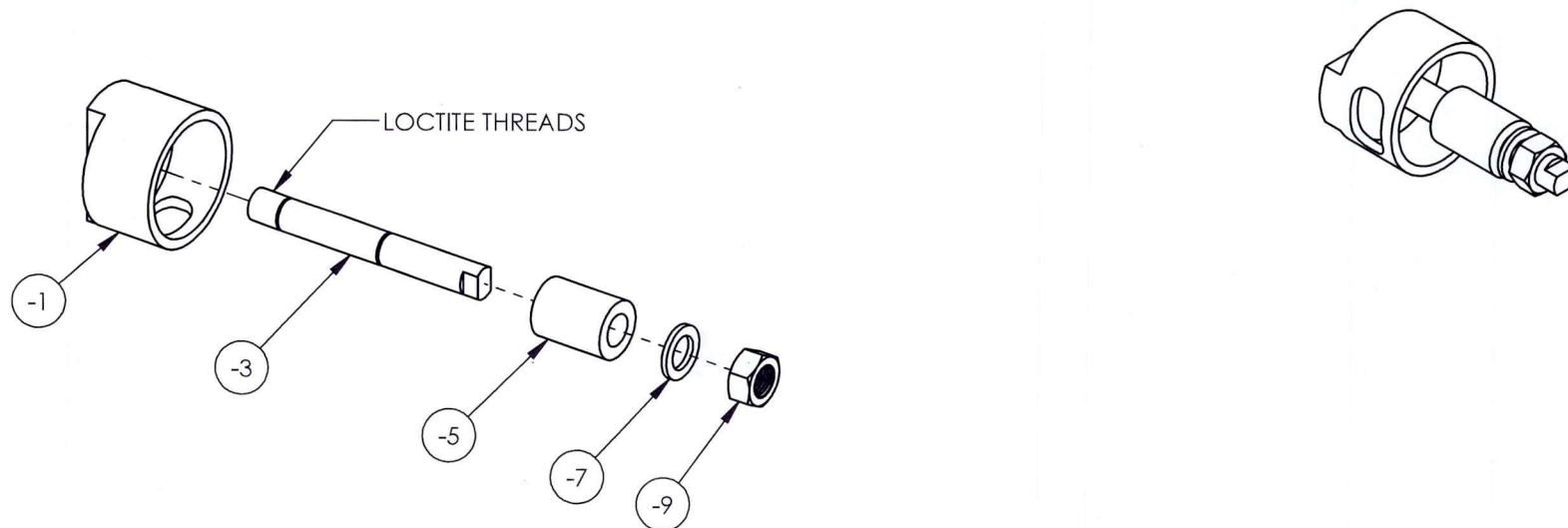
Specifications could not be found.

Plex 4/1/19 8:48 AM Dart.Hadley.Shannon



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| REVISIONS |         |                                                                                                                                                                                                       |           |         |          |
|-----------|---------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|---------|----------|
| REV       | ECR     | DESCRIPTION                                                                                                                                                                                           | DATE      | INITIAL | APPROVED |
| A         |         | BROKE OUT INTO INDIVIDUAL TOOLS FROM KIT RBW6305G00132-3G.                                                                                                                                            | 4/7/2011  | RJC     |          |
| 1         |         | -3 CH'D DIM WAS $\varnothing.375$ IS $.370 +.000 -.005$ , ADDED THREAD NOTE $\varnothing.370-.367$ . -5 CH'D DIM WAS $\varnothing.381$ IS $\varnothing.375 +.005-.000$ .                              | 5/10/2013 | CFS     | GE       |
| 2         |         | -3 CH'D MATERIAL WAS 4140 Q&T IS 4140/4142.                                                                                                                                                           | 5/6/2014  | LA      | RJC      |
| 3         | 15-0321 | -1 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -3 DELETED DIMS $\varnothing.370 +.000-.005$ AND $\varnothing.370-.367$ . -5 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. | 10/2/2015 | RJC     | JAG      |



#### NOTES:

1. REF. AGUSTA T/N: 3G6305G01232.
2. PART OF KIT RBW6305G00132-3G.

|                                                                                                                                                                   |                                                                               |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------|
| <b>DART<br/>AEROSPACE</b>                                                                                                                                         |                                                                               |
| TITLE<br>GIMBAL TORQUE TUBE BUSHING REMOVER                                                                                                                       |                                                                               |
| DWG NO.<br>RBW6305G01232-3G                                                                                                                                       | REV<br>3                                                                      |
| MAT'L<br>UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>.XXX $\pm .005$<br>.XX $\pm .01$<br>.X $\pm .1$<br>FRACTIONS $\pm 1/8$<br>ANGLES $\pm 5^\circ$ | DRAWN BY: PERRITT<br>APPROVED: <i>D. Weir</i><br>HEAT TREAT<br>FINISH<br>SPEC |
| 1. BREAK ALL SHARP EDGES .015 x 45°<br>OR .015R<br>2. DIMENSIONAL LIMITS APPLY AFTER PLATING                                                                      | USED ON MODEL<br>AGUSTA                                                       |
| SCALE 1:2                                                                                                                                                         | DATE 4/7/2011                                                                 |
| SHEET 1 OF 4                                                                                                                                                      |                                                                               |

| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description | Material            | B/O INFORMATION OR SPECIFICATIONS                                 | PG. |
|----------|----------|-----|--------|----------|-------------|---------------------|-------------------------------------------------------------------|-----|
|          |          |     | -1     | 1        | RECEIVER    | 4140 Q&T / 4142 Q&T |                                                                   | 2   |
|          |          |     | -3     | 1        | STUD        | 4140/4142           | $\varnothing 3/8 \times 3-1/8$ (MCMaster-CARR #8935K336) MODIFIED | 3   |
|          |          |     | -5     | 1        | SPACER      | 4140 Q&T / 4142 Q&T |                                                                   | 4   |
|          |          | B/O | -7     | 1        | WASHER      | STEEL               | $\varnothing 3/8$ AN960-616L                                      | 1   |
|          |          | B/O | -9     | 1        | HEX NUT     | STEEL               | 3/8-24 UNF -2B AN315-6                                            | 1   |
|          |          | B/O | -11    | 1        | LOCTITE 262 |                     | AS REQUIRED                                                       | N/S |



Dart Aerospace Ltd.  
1270 Aberdeen St  
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K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## PO042703



**Supplier:** ARR002-VU  
Arrow Tech Machine Works  
29751 E. Enid Road,  
Unit C  
Eugene, OR 97402 USA  
Phone: 541-780-6938  
Fax: 458-215-4938

**PO No:** PO042703  
**PO Date:** 2/25/19  
**Due Date:** 4/29/19  
**Purchase Order Revision:**  
**Revision Date:**  
**Ship-To Contact:** Phone:

**Ship To:**

**Pymt Terms:** Net 30  
**Freight Terms:**  
**Special Comments:**

### Items

| Line Item | Job    | Part              | Supplier Part No | Item No | Description                                     | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (USD) | Extended Price |
|-----------|--------|-------------------|------------------|---------|-------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| 1         | 191247 | RBW6305G01232-3GP |                  |         | Gimbal Torque Tube Bushing Remover REV 3        | Firmed | -       | 4/29/19  | 2 Ea           | 0 Ea              | 2 Ea    | \$708.34/Ea      | \$1,416.68     |
| 2         | 191252 | RBW6205G13231-3GP |                  |         | Arm Assembly As Per Dwg RBW6205G13231-3G Rev. 1 | Firmed | -       | 4/29/19  | 9 Ea           | 0 Ea              | 9 Ea    | \$298.00/Ea      | \$2,682.00     |
| 3         | 191253 | RBW6305G00232-3GP |                  |         | Gimbal Torque Tube Bushing Installer REV 2      | Firmed | -       | 4/29/19  | 2 Ea           | 0 Ea              | 2 Ea    | \$708.75/Ea      | \$1,417.50     |
| 4         | 191255 | RBW6205G06131-3GP |                  |         | Main Rotor Pitch Control Lever Expander REV D   | Firmed | -       | 4/29/19  | 4 pcs          | 0 pcs             | 4 pcs   | \$913.63/pcs     | \$3,654.52     |
| 5         | 191258 | RBW6205G03731-3GP |                  |         | Trim Tab Bending Gauge Assembly REV 4           | Firmed | -       | 4/29/19  | 3 Ea           | 0 Ea              | 3 Ea    | \$1,204.00/Ea    | \$3,612.00     |

**Grand Total: \$12,782.70**

lost  
savings  
232.12  
464.24



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## PO042703



### Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

#### Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "P. Lussier".

Plex 2/25/19 2:20 PM dart.Lussier.Patrick





**PHGE Machineworks dba  
Arrowtech Machineworks**  
29751 E Enid Rd. Unit C  
Eugene, Oregon 97402  
Phone: (541) 780-6938  
Fax: (458) 215-4938

## Packing Slip

NO. 491

Date: 3/28/2019  
PO Ref: 042703  
Ship via: Fedex Priority

Bill To:  
Dart Aerospace  
1270 Aberdeen St. Hawkesbury, ON  
CANADA K6A 1K7

Ship To:  
Dart Aerospace  
1271 Aberdeen St. Hawkesbury, ON  
CANADA K6A 1K8

**Qty**

**Item**

**Part No.**

9 ✓

ARM ASSEMBLY

✓ RBW6205G13231-3G

4 ✓

M/R PITCH CONTROL LEVER EXPANDER

RBW6205G06131-3G ✓

2 ✓

GIMBAL TORQUE TUBE BUSHING INSTALLER

✓ RBW6305G00232-3G

2 ✓

GIMBAL TORQUE TUBE BUSHING REMOVER

✓ RBW6305G01232-3G

DAS  
68  
9-89

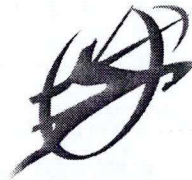
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Received by: \_\_\_\_\_

Packaged by: J.M.L

Checked by: AJP

Thank You



**ARROW TECH MACHINE WORKS**

## **Certificate of Conformance**

Your Purchase Order No: 042703 ✓

Dated: 3/28/2019

Our Order / Job No: 042703-1AWT

Order Qty: 2 ✓

Part Name: GIMBAL TORQUE TUBE BUSHING REMOVER

Part Number: RBW6305G01232-3G ✓

Lot Size: N/A

Ship Date: 3/28/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G01232-3G

Rev: 3

Material Size and Type: -1, -5/4140 Q&T STEEL; -3/4140

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: (28-32 HRC)

Plating/Finish: ZINC PLATE: ASTM B633 TYPE 2 CLASS 2

**Mercury Contamination:** The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: \_\_\_\_\_

03/28/19

Signed: \_\_\_\_\_

DAS  
68  
9-89

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**PHGE Machine Works LLC dba Arrow Tech Machine Works**  
29751 E. Enid Rd. Unit C Eugene, Oregon 97402  
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